



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G09132-3G-PO
Job Sheet 186473



Part No: RBW6205G09132-3G-PO **Job Qty:** 1 ea

Part Name: Trolley Adapter, Swashplate Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 12/21/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G09132-3G Rev 3 IPP Rev A outsource 18.09.18 DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	12/21/18	12/21/18	0.00	0.00	Purchasing		DEC 27 2018
110	Packaging	1 pcs	12/21/18	12/21/18	0.00	0.00	Packaging2		DEC 27 2018
120	QC	1 pcs	12/21/18	12/21/18	0.00	0.00	QC6		38
130	Small Fab	1 pcs	12/21/18	12/21/18	0.00	0.50	Small Fab-4		9-89 DAS
140	QC	1 pcs	12/21/18	12/21/18	0.00	0.00	QC5		68
150	Packaging	1 pcs	12/21/18	12/21/18	0.00	0.00	Packaging3-1		28 9-89
160	QC21-FG	1 Ea	12/21/18	12/21/18	0.00	0.00	QC21		9-89

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 041754 MANUFACTURE RBW6205G09132-3G AS PER Descriptions: DWG -Certificate of conformity is required

130 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into RBW6205G09132-3G. 3-Install placard using drive screws.

NOV 16 2018 x1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G09132-3GP	Trolley Adapter, Swashplate Support	1 pcs (1 ea)	100-Purchasing	S140312
91654A076	Drive Screw #2 3/16" Long	4 Ea (4 ea)	130-Small Fab	5015391
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	130-Small Fab	5021040

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G09132-3GP	1	0	0
130-Small Fab	91654A076	4	68	0
	RB41011	1	702	0



Container No: S140313



Part: RBW6205G09132-3G

Job No: 186473

Serial No/Batch: S140313

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

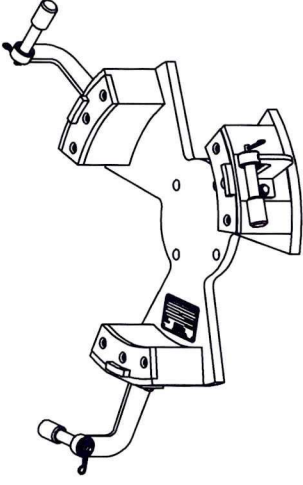
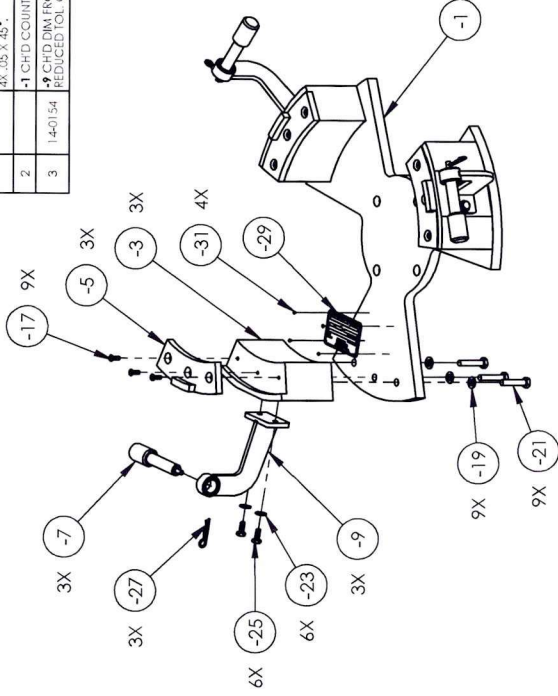
cations

not be found.

Plex 11/16/18 8:49 AM dart.Lussier.Patrick

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 CHD COUNTERBORE WAS .594 $\pm$.390 IS .594 $\pm$.39. -3 CHD HOLE DEPTHS WAS .394 IE .39. WAS 1.000 IS .100. WAS .625 IS .63. -7 ADDED NOTE "CENTER OK". -13 CHD CHAMFER WAS 4X .050 X 45°. IS 4X .035 X 45°.	6/25/2013	BM	GE
2		-1 CHD COUNTERBORE HOLES FROM ϕ .5.375 B.C. TO ϕ .5.512 B.C.	7/19/2013	RJC	RW
3	1-40154	-9 CHD DIM FROM 4.144 TO 3.92. -11 CHD DIM FROM 4.562 TO 4.32. UPDATE TITLE BLOCK TO DART. REDUCED TOL ON NON-CRITICAL DIMS.	9/19/2014	JAG	DW



ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-1	1	BASE	6061	5/8 X Ø1.5-3/4	2
		-3	3	BLOCK	6061	2-3/8 X 3-5/8 X 6-3/8	3
		-5	3	WEAR PLATE	WHITE NYLON	1 X 2-5/16 X 6-1/8	4
		-7	3	PN	6061	Ø1 X 4-3/4	5
X		-9	3	ARM WELDMENT			6
1		-11		ARM	1018	1/4 X 4-1/4 X 4-1/2	7
1		-13		PIVOT	1018	Ø1-3/16 X 7/8	8
1		-15		PLATE	1018	3/8 X 1-5/8 X 2-1/2	9
	B/O	-17	9	FLATHEAD SCREW	STEEL	M5 X .8 X 1.4mm. McMaster-Carr #91420A3-4	1
	B/O	-19	9	WASHER	STEEL	M8 McMaster-Carr #9116A-270	1
	B/O	-21	9	SCREW	STEEL	M8 X 1 X 40mm. McMaster-Carr #91180A-540	1
	B/O	-23	6	WASHER	STEEL	1/4 McMaster-Carr #90126-A029	1
	B/O	-25	6	SCREW	STEEL	1/4-20 X 3/8 McMaster-Carr #92620A539	1
	B/O	-27	3	HARPNUT COITER PIN	STEEL	McMaster-Carr #9835A058	1
	B/O	-29	1	DART PLACARD	ALUMINUM	RB41011	1
	B/O	-31	4	#2 DRIVE SCREW	COATED STEEL		1
ASSY -9							

NOTE:
ENGRAVE -29 PLACARD WITH T/N, S/N, "MADE IN USA".



TITLE TROLLEY ADAPTER, SWASHPLATE SUPPORT

DWG NO. RBW6205G09132-3G

REV	3
DRAWN BY:	GILBERT
APPROVED:	D. Ward
UNLESS OTHERWISE SPECIFIED	
1. DIMENSIONS IN PARENTHESES ARE RECOMMENDED	
2. FRACTIONS $\pm$ 1/8	
3. ANGLES $\pm$ 5°	
4. ALL SHARP EDGES .015 X 45°	
5. BREATHER OR OTHER	
6. DIMENSIONAL LIMITS APPLY AFTER PLATING	
7. USED ON MODEL	
8. AW139	
9. SCALE 1:8	
10. DATE 1/19/2012	
11. SHEET 1 OF 9	

Need one more for siof



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041754**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO041754
PO Date: 11/16/18
Due Date: 12/21/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Ship To:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Revised.

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	186473	RBW6205G09132-3GP			Trolley Adapter, Swashplate Support REV 3	Firmed	-	12/21/18	1 pcs	0 pcs	1 pcs	\$2,698.00/pcs	\$2,698.00
Line Item Note SIOP													
Grand Total:													\$2,698.00

Order Notes

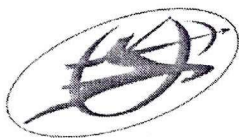
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Plex 12/5/18 11:48 AM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 370

Date: 12/21/2018
PO Ref: 041754 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty

1 ✓

Item

TROLLEY ADAPTER SWASHPLATE SUPPORT

Part No.

RBW6205G09132-3G ✓

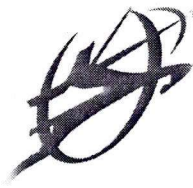
DAS
38
9-88

Received by: _____

Packaged by: _____

Checked by: Q.E.

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 041754 ✓ Dated: 12/21/2018

Our Order / Job No: 041754-1AWTAWT Order Qty: 1 ✓

Part Name: TROLLY ADAPTER, SWASHPLATE SUPPORT

Part Number: RBW6205G09132-3G ✓

Lot Size: N/A Ship Date: 12/21/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6205G09132-3G Rev: 3

Material Size and Type: -1,-3-7/6061, -5/WHITE NYLON,-11,-13,-15/ 1018

Material Specifications: ALUM.: ASTM B221,; NYLON: D5989; STEEL:ASTM A108 ,
ASTM A29,

Heat Treatment: N/A

Plating/Finish: CLEAR
TYPE I SC 2

Mercury Contamination: Th
mercury bearing instruments

No Rush
for stock.

S I ZINC PLATE ASTM B633

ome in contact with mercury or

Date: 12/21/18

DAS
38
9-89

PHGE Machine Works LLC dba Arrow Tech machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
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www.atechmachineworks.com